

5/36

SPIT

DART AEROSPACE LTD	Work Order:	24090A
Description: Lug	Part Number:	D2230-3
Drawing: D2230 Rev. F	Qty:	300

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	RF	05.08.23	300
2	METAL	Cut D2423 extrusion to 0.82"			
3	HAAS	Machine per folio D2230-3 issue P.O. 2008529 Batch: D21202 NIA			
4	QC RG	Check for crack while loading into the machine Inspect Level 2		05/08/24	300
5	QC6	Receive & inspect for transit damage Inspect Level 6	CL	05/09/20	289
6	METAL	Tumble and deburr rough edges after tumbling if applicable tumble	FF	05.11.28	289
7	METAL	Acid etch and Alodine per QSI 005 4.1	FT	05.11.28	289
8	QC	Inspect Level 5	MM	06/03/03	289
9	FINISHING	Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3	DL	06/03/03	289
10	QC	Inspect Level 3	CL	06/03/06	285
11	STORES	Identify and stock	CL	06/03/06	285
12	EXPEDITING	Close W/O Job Cost / Part		06.03.07	285

LEVEL 21 INSPECTION.

Rev	Date	Change	Revised By	Approved
A	97.02.21	New Issue		
B	98.06.01	Re-Format	KB	
C	00.01.27	Re-Format, added level 2 insp., Rev. F (mpp 2022)	EC	
D	00.05.18	Added inspection level 8, and removed P/O for powder coat	EC	

RELEASED

EC 00.05.24

RF
03.05.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/03/07

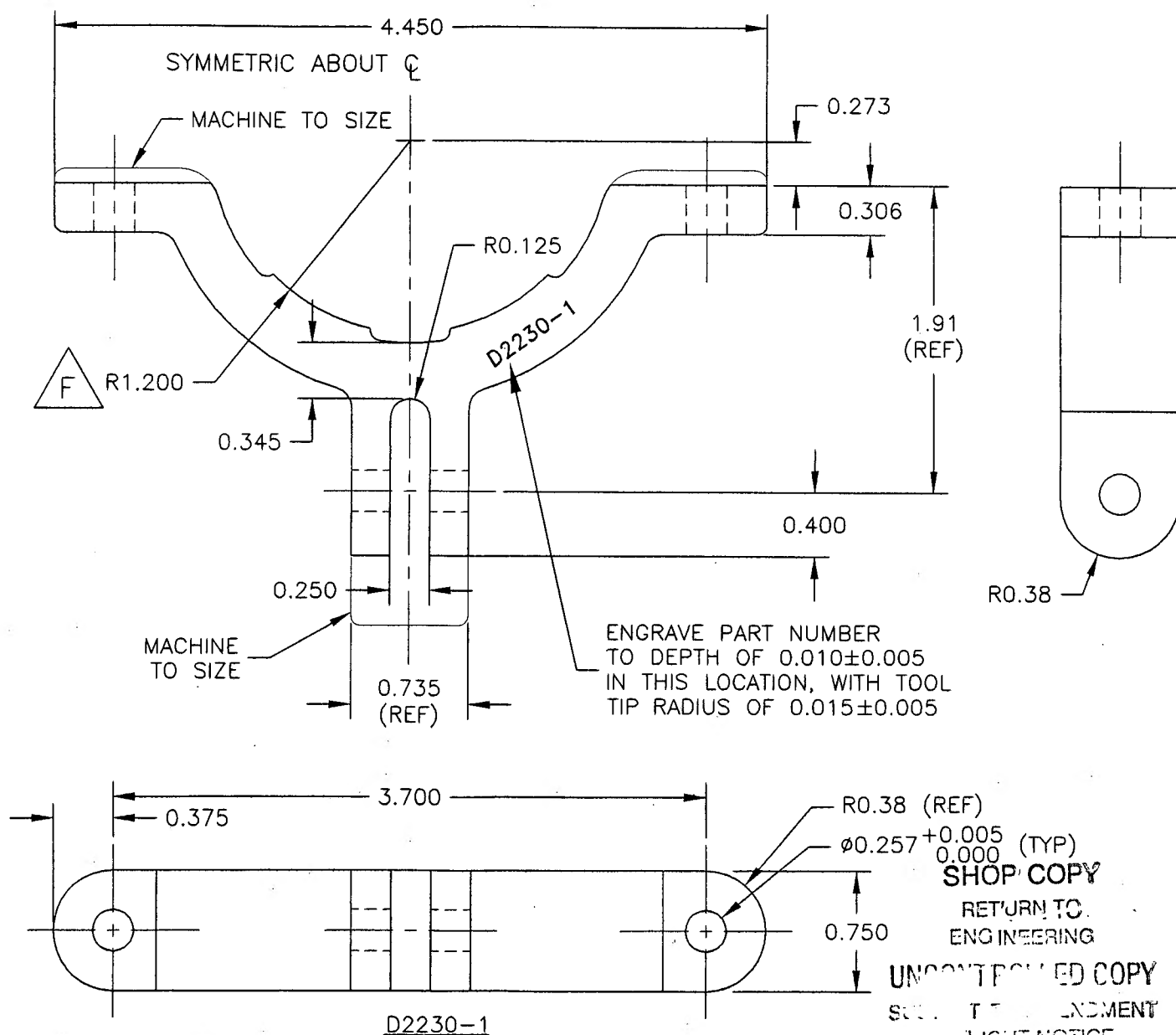
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	th	APPROVED	th	DRAWING NO. D2230
				REV. F SHEET 1 OF 2
DATE	99.12.13	TITLE	MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN		
D	95.01.04	RE-DESIGN		
E	95.01.04	RE-DESIGN		
F	99.12.13	REDESIGN; R1.200 WAS R1.100		

RELEASED
99-12-21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

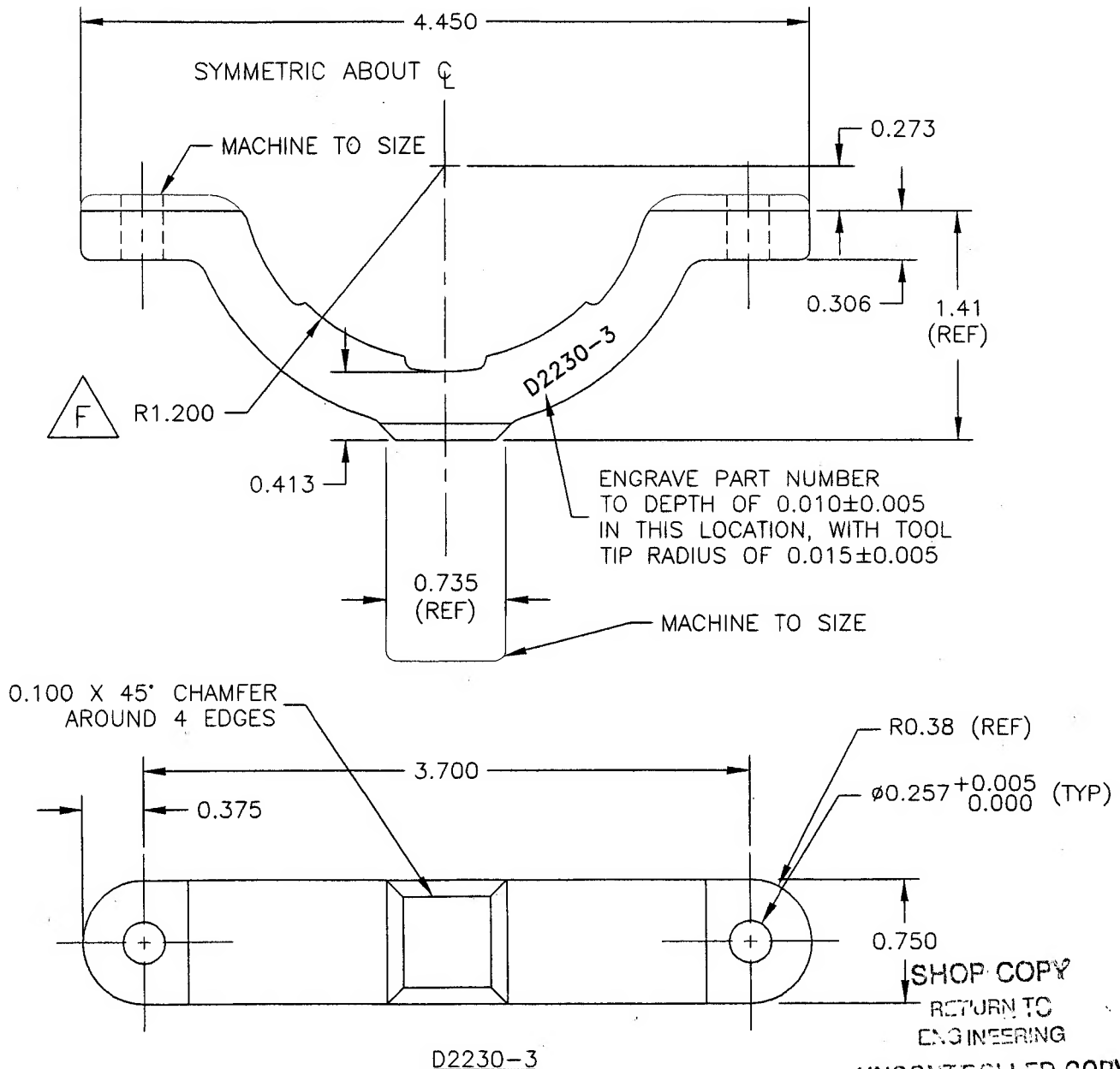
WORK ORDER
NO. 24090

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WITHOUT NOTICE



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 24090

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 18, 2005
10:59 am

Work Order No : 0024090
Project Name : D2230-3
Project For : WK536
Work Order Type : Main
Main WO Number :
House Part Number : D2230-3
Description : Mounting Lug
Manufactured : Yes
Amount Req'd : 300
Amount Done : 0
Start Date : 08-17-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00